

Date: Wednesday, 6/27/2007 1:08:20 PM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: SADDLE SPACER		
Job Number	33219	Part Number	: D2935		
Estimate Number	11063	Drawing Number	: D2935 REV B		
P.O. Number	N/A	Project Number	: N/A		
This Issue	6/27/2007	S.O. No.	: N/A		
Prsht Rev.	NC	Drawing Revision	: B		
First Issue	N/A	Material	: N/A		
Previous Run	32469	Due Date	: 7/4/2007 Qty: 60 Um: Each		
Written By	:				
Checked & Approved By	:				
Comment	: Est A 00.06.06 New Issue EC				
	Est Rev:B Now 6061-T6 06-06-23 JLM				

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :	
1.0	M6061T6S080	6061-T6 .080 Sheet	
		Comment: Qty.: 0.0532 sf(s)/Unit Total : 3.1941 sf(s) Material: M6061-T6 0.080" Thick Batch <u>M104921</u>	<u>SAD 07/07/28</u>
2.0	WATER JET	FLOW WATER JET	
		Comment: FLOW WATER JET 1-Cut as per Dwg D2935 Dwg Rev: <u>B</u> Prog Rev: <u>B</u>	
		2-Deburr if necessary	<u>SAD 07/07/28 60</u>
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE	
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE	<u>SAD 07/07/28 60</u>
4.0	QC8	SECOND CHECK	
		Comment: SECOND CHECK	<u>EN 07/07/30</u> <u>(X61)</u>
5.0	HAND FINISHING1	HAND FINISHING RESOURCE #1	
		Comment: HAND FINISHING RESOURCE #1 Acid etch and Alodine as per QSI 005 4.1	<u>A. m 07.07.30</u> <u>(61)</u>

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 08/07/130
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE SPACER

Job Number: 33219

Part Number: D2935

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6/27/11/30 6/

7.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: STS59

6/1

6/27/11/30

8.0 QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

6/27/11/30

(6)

Job Completion



6/27/11/30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	33219
Description: Saddle Spacer	Part Number:	D2935
Inspection Dwg: D2935	Rev: B	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

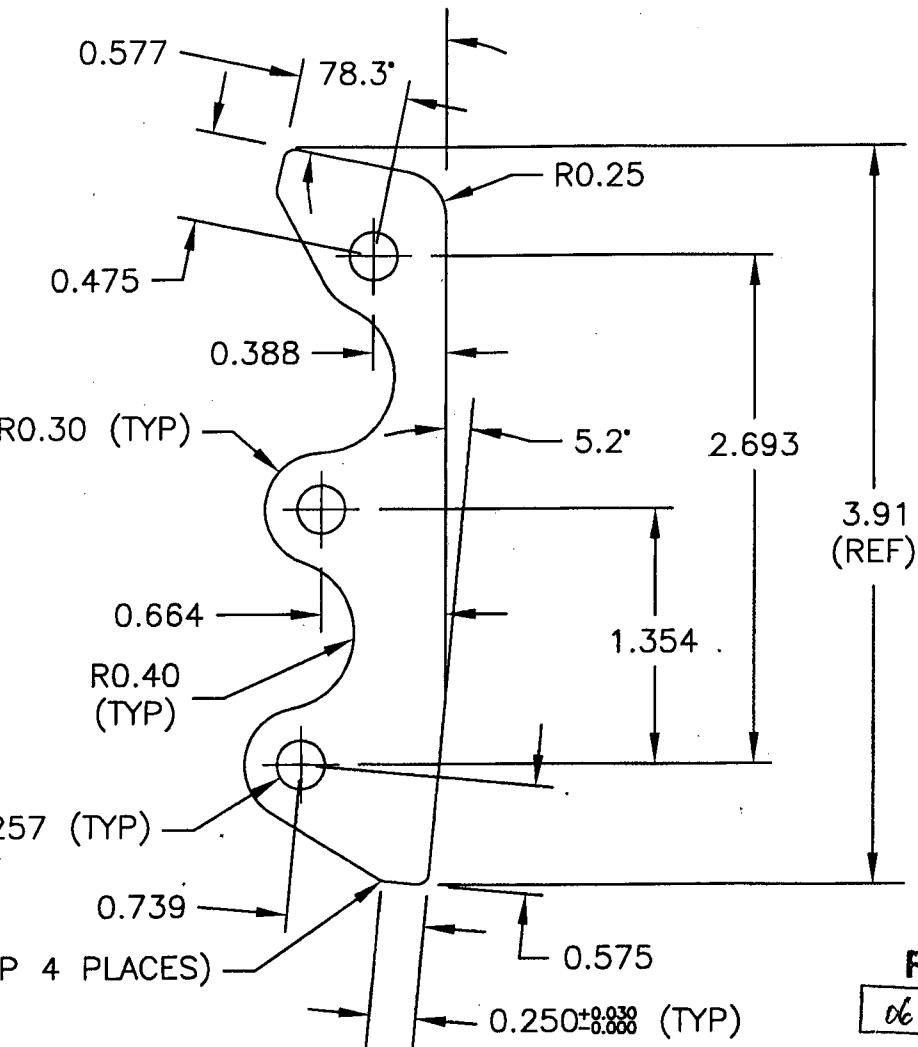
X First Article Prototype

Measured by:	SAB	Audited by:	EP	Prototype Approval:	N/A
Date:	07/07/23	Date:	07/07/30	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	06.06.05	New Issue	KJ/JLM	
B	06.06.23	Dwg Rev. changed	KJ/JLM	JL

DART

DESIGN <i>TT</i>	DRAWN BY <i>CB</i>	DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED <i>PH</i>	APPROVED <i>MM</i>	DRAWING NO. D2935	REV. B SHEET 1 OF 1
DATE 06.05.29		TITLE SADDLE SPACER	SCALE 1:1
A	99.11.02	NEW ISSUE	
B	06.05.29	ADD 6061-T6 MATERIAL	

**NOTES:**

- 1) MATERIAL: 6061-T6 (PER QQ-A-250/11 OR AMS 4025 OR AMS 4027) 0.080" THICK
(REF DART SPEC M6061T6S.080)
OR
5052-H32/H34 (PER QQ-A-250/8 OR AMS 4016) 0.080" THICK
(REF DART SPEC M5052H32S.080)
 - 2) FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
 - 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
 - 5) ALL DIMENSIONS ARE IN INCHES
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NO. 33219